

Work Order ID 123544

123544

Page 1

Thursday, August 07, 2014 11:18:20 AM

Item ID: D3428-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Placard
Start Date: 8/08/14 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 8/08/14 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: MCS Date: 14-08-11 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3428 | Rev A |

100 PURCHASING 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 25406

Manufacture as per Dwg D3428 using 3M 7mil masking film #8522CP or Avery IPM #2031

Possible Supplier: Studio Lettrage

Material release note is required

cmg 14/8/15

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

Ensure material release note is attached

12x SP 14-8-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | |
|--|--|--|--|--|---|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence |
| <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | |
| <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | |

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| 120 *120* QC Quality Control | QC6- Inspect dimensions to drawing Memo | 0.00 0.00 | D 1.5 9-89 | 14/08/18 | | 12 | | | |
| 130 *130* Packaging Packaging | Identify as per dwg & Stock Location: Sto38 Memo | 0.00 0.00 | | | | 12 | | | DAS 06 AUG 18 2014 9-89 |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | MLJ 14-08-18 MLJ 14-08-18 |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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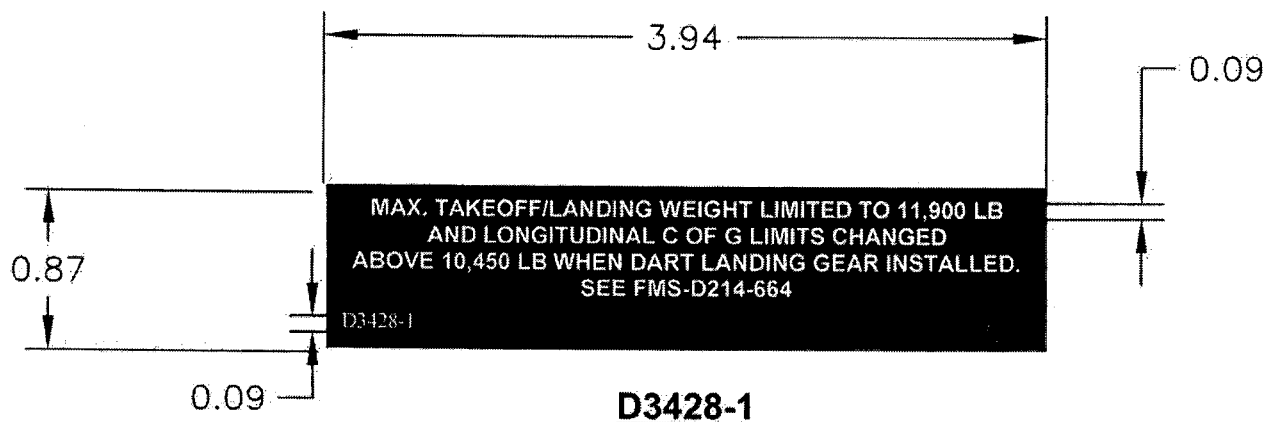
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|--|--|---|--|



| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3428 | REV. A SHEET 1 OF 1 |
| DATE 05.06.07 | TITLE PLACARD | | SCALE 1:1 |
| A | 05.06.07 | NEW ISSUE | |



RELEASED
05.06.07 [Signature]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 123544 MLS
14-08-11



- 1) MATERIAL: WHITE LETTERS ON BLACK ADHESIVE BACK
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP
OR AVERY IPM #2031
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED.

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID P025355

Purchase Order Date 8/11/2014

PO Print Date 8/13/2014

Page Number 1 of 2

Order From :

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

VC-STU001

Ship To :

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 632 5449

Ship To Contact

Ship To Phone

Ship Via

VENDOR'S TRUCK

Ship Acct

Buyer

Michael Gregoire

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

| Line Nbr | Reference Vendor Part Number Line Comments Delivery Comments | Description/ Mfg ID | Req Date/ Taxable Promise Date | CD | Req. Qty/ Unit of Measure | PO Unit Price | Extended Price |
|---|--|------------------------|--------------------------------------|----|---------------------------------|---------------|----------------|
| 1 | D4917-315P | Placard, Max Load | 8/20/2014 Yes 8/20/2014 | | 12.00 Each | \$6.66 | \$79.92 |
| Manufacture as per Drawing D4917 rev.A B123341 | | | | | | | |
| Line Total: | | | | | | | \$79.92 |
| 2 | D3428-1P | Placard | 8/20/2014 Yes 8/20/2014 | | 12.00 Each | \$6.66 | \$79.92 |
| Manufacture as per Drawing D3428 rev.A B123544 | | | | | | | |
| Line Total: | | | | | | | \$79.92 |

6814-8-15

Note:

8/13/2014

Studio de Lettrage

210 Main Street W
Hawkesbury, Ontario K6A 2H6

INVOICE

Invoice No.: 22800
Date: 08/14/2014
Ship Date:
Page: 1
Re: Order No. WO13261

Sold to:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Ship to:

Dart Aerospace Ltd
Hawkesbury, Ontario

Business No.: 82500 7651 RT0001

| Item No. | Unit | Quantity | Description | Tax | Unit Price | Amount |
|--|------|----------|---------------|-----|--------------|--------|
| | | 12 | PQ# 25355 | H | 6.6667 | 80.00 |
| | | 12 | D4917-315P | H | 6.6667 | 80.00 |
| | | 12 | D3428-1P | | | |
| | | | Mike Gregoire | | | |
| | | | H - HST 13% | | | 20.80 |
| | | | HST | | | |
| Studio de Lettrage HST: #825007651RT0001 | | | | | | |
| Shipped By: Tracking Number: | | | | | Total Amount | 180.80 |
| Comment: | | | | | | |
| Sold By: | | | | | | |

60148-15

| | | | | | |
|--|--|--|--------------------------------------|----------------------------|------------------|
| Customer: Studio de letrage 2001 | | Purchase Order #: 10 # 25355 | Packing Slip #: WO # 13241 | Part #: 24 total | Serial #: |
| Certificate of Conformity | | | | | |
| Approval: AUTH | | | | | |
| Signature: [Signature] | | | | | |
| Title: Production Coordinator | | | | | |
| DATE: Aug 14 | | | | | |

1. The above the listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications.
 2. All work was accomplished in accordance with the Dart Aerospace Purchase Order.
 3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

We hereby certify that

Certification:

PRODUCT DATA SHEET



Avery® IPM™ 2031

issued: 01/04/2005

Introduction

Avery® IPM™ 2031 is a high quality pressure-sensitive vinyl film, designed for use on wide format inkjet printers. Avery® IPM™ 2031 has excellent printing properties, allowing crisp print quality with bright and vibrant colours. Avery® IPM™ 2031 offers rapid ink drying and a water-resistant material. It combines good adhesion during its life and easy removal afterwards.

Description

Facefilm: 80-micron premium white calendered, topcoated vinyl.

Adhesive: removable, acrylic based

Backing paper: one side coated kraft paper, 140 g/m²

Features

- Excellent printability
- Vibrant and bright colours
- Crisp print quality
- Spray water resistant with specific pigmented inks
- Good adhesion, excellent removability
- Warranty on outdoor durability

Recommendations for use

A wide variety of full-colour graphics for indoor - and short/medium term outdoor applications such as posters, murals, displays, exhibition stands, vehicle graphics etc. Avery® IPM™ 2031 is suitable for application to a wide variety of substrates and will remove cleanly for up to 1 year after application.

IPM media should be handled with care as any surface contamination may affect the print quality. Media should be processed in an environment of 15-25°C and 30-70% relative humidity. After drying, the finished prints should be wrapped in polyethylene film and despatched flat or rolled with the printed side facing outwards. To protect prints against water, UV/light and abrasion, overlamination with a clear film is recommended. For specific details of Avery® DOL combinations, refer to "Technical Bulletin 5.3. Recommended combinations of Avery® Overlaminates and Avery® Digital Print Media"

Always test your combination of Avery® IPM™ medium, inkjet printer and inks prior to commercial use.

Compatibility

Avery® IPM™ 2031 is compatible with a broad selection of inkjet printers, when printing with pigmented, water based inks. For specific details refer to "Technical Bulletin 5.6 Avery Dennison Inkjet Print Media - Printer compatibility".

Durability:

Avery® IPM™ 2031 is warranted for outdoor use in conjunction with pigmented outdoor inks from HP, Encad and Colorspan. The warranted period varies from type of application and type of overlaminate from 18 months up to 5 years. For full details, see our Avery® IPM™ Outdoor warranty.



Graphics Division
Rindijk 88, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538

PRODUCT CHARACTERISTICS

Avery® IPM™ 2031

Physical properties

| Features | Test method ¹ | Results |
|---|---|--|
| Caliper, facefilm | ISO 534 | 80 µm |
| Gloss | ISO 2813, 20° | 1% |
| Dimensional stability | DIN 30646 | 0.3 mm. max |
| Adhesion, initial | FINAT FTM-1, stainless steel | 180 N/m |
| Adhesion, ultimate | FINAT FTM-1, stainless steel | 260 N/m |
| Flammability | | Self extinguishing |
| Accelerating ageing | DIN 53587, 500h exposure | No negative impact on film Performance |
| Shelf life | Stored at 22° C/50-55 % RH | 2 years |
| Removability | | up to 1 year |
| Not when applied to: Nitro-cellulose paints, ABS, Polystyrene, certain types of PVC | | |
| Durability ² | Overlaminated with DOL 4300 | 5 years |
| | Overlaminated with DOL 1000, DOL 1100 with overlaps | 3 years |
| | Overlaminated without overlaps for static applications only | 2 years |
| | Without overlaminate and used for static, Non-abrasive application ONLY | 18 months |

Only when printed with ENCAD GO, HP and Colorspan pigmented inks and when properly applied in accordance with our application instructions. Only applicable for vertical exposure.

Temperature range

| Features | Results |
|-------------------------|----------------|
| Application temperature | Minimum: +10°C |
| Service temperature | -20°C to +80°C |

Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use.

All technical data are subject to change. In case of any ambiguities or differences between the English and foreign versions of these Conditions, the English version shall be controlling.

Warranty

Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing.

All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

1) Test methods

More information about our test methods can be found on our website.

2) Durability

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



www.averygraphics.com

Graphics Division
Pindijk 86, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538